

Date: Tuesday, 11/29/2005 4:30:46 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 25023	
Estimate Number : 10643	
P.O. Number : N/A	Part Number : D31633 → D3163-041 (b#)
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D3163 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 12/6/2005
Checked & Approved By : <u>SEE COMMENT BELOW</u>	Qty: <u>6</u> Um: Each
Comment : Est. B 05.10.25 Remove Powder Coat K/J/R/F	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 10 00000189

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3163

Possible Supplier: GFI

Material release note is required

AP 0511130
M 2024T3S.063
make by hand

Batch # m16645m1605.2 (1x)FF 06-01-25FF 05.12.01

6

2.0	D31633F	Plate
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Comment: Qty.: 1.0000 U(s)/Unit Total: 2.0000 U(s)
 Plate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-01-30

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur

FF 05-12-01

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 01/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLATE

Job Number: 25023

Part Number: D31633

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-01-25

6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-25

6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA

FF 06-01-30

6

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/17

6

06/01/31

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-01-25	5	NUT Plate: MS 21059408 # m 10015 9x NUT Plate: MS 21059408 # m 12502 3x NUT Plate: MS 20920 AD 3-4 # m 15786 22x	FF	06-01-25				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

REV. B

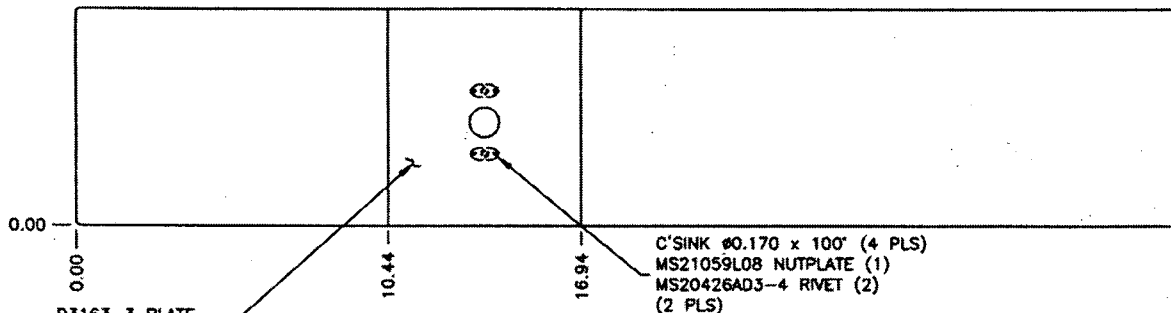
SHEET 1 OF 1

SCALE

1:6

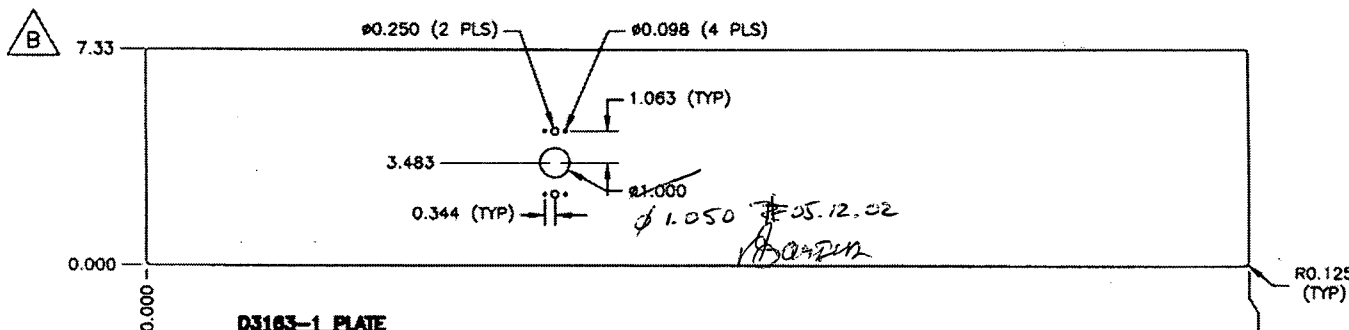
DESIGN	DRAWN BY	DRAWING NO.	TITLE
11	11	D3163	PLATE
CHECKED	APPROVED		
DATE			
04.10.06			
A	02.04.26	NEW ISSUE	
B	04.10.06	7.33 WAS 7.20; REMOVE PERIMETER HOLES	

RELEASED
04.11.23

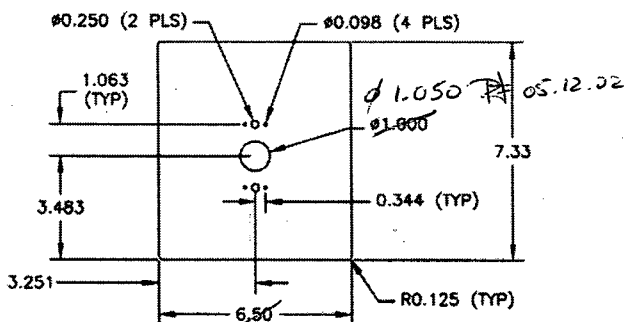


D3163-3 PLATE
BOND TO D3163-1
USING SIKAFLEX 241/291
AHESIVE

D3163-041 PLATE SHOWN, POSSIBLE SUPPLIER: PREMIER P/N B30-23000-10
(D3163-042 PLATE OPPOSITE, POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)



D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)



D3163-3 PLATE
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)

- GENERAL NOTES:**
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 - 2) BREAK SHARP EDGES 0.005 TO 0.010
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

UNDER REVIEW
05.11.21

CANCEL
05.12.02